

# Work Order ID 74696

Wednesday, October 05, 2011 11:04:40 AM



Page 1

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 10/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D212-664-241

Rev D

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Blend transition lines only, \*\*do not sand whole tube\*\*.

FOLIO REV: AD

DWG REV: B

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

1 Ø

M.M.L 11/11/21

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

11 Ø

M.M.L 11/11/21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 74696

Wednesday, October 05, 2011 11:04:40 AM



Page 2

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 10/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA114

2-Blend transition lines only, \*\*do not sand whole tube\*\*

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

FOLIO REV: AD

DWG REV: B

3-Remove sand and plugs

4- scribe batch # and part # as per dwg

1 0

MAN.L 11/11/21

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

1 0

MAN.L 11/11/21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Work  
Wedne

# Work Order ID 74696

Wednesday, October 05, 2011 11:04:40 AM



Page 3

Item I  
Revisi  
Item N  
Start  
Requi  
Refer  
Appro

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 10/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Seque  
Work  
170  
Packag  
Packag  
180  
QC  
Quality

| Sequence ID/<br>Work Center ID                     | Operation<br>Description                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140<br><br>QC<br>Quality Control                   | QC8- Inspect parts - second check<br><br>Memo | 0.00<br><br>0.00     | DP      |        |              | 11-11-22      |               |                  |                |
| 150<br><br>HandFXtube<br>Hand Finishing Crosstubes | Crosstubes Chemical Conversion<br><br>Memo    | 0.00<br><br>0.00     | mo      |        |              | 11-11-23      |               |                  |                |
| 160<br><br>QC<br>Quality Control                   | QC3- Inspect Part Finish<br><br>Memo          | 0.00<br><br>0.00     |         |        |              | DP 11-11-25   |               |                  |                |

Dart Dart Aerospace Ltd

W/O:

W/O:

**WORK ORDER CHANGES**

DATE

DATE

STEP

PROCEDURE CHANGE

By

Date

Qty

Approval  
Chief Eng /  
Prod Mgr

Approval  
QC Inspector

Part

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

NCR:

**WORK ORDER NON-CONFORMANCE (NCR)**

DATE

DATE

STEP

Description of NC  
Section A

Corrective Action Section B

Initial  
Chief Eng

Action Description  
Chief Eng

Sign &  
Date

Verification  
Section C

Approval  
Chief Eng

Approval  
QC Inspector

NOT

**NOTE:** Date & initial all entries

H:\FC

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

# Picklist Print

Wednesday, October 05, 2011 11:04:47 AM

Page 1

Work Order ID: 74696



Parent Item: D212-664-201TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
IPP Rev B 08.04.02 Removed polish EC verified DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6006-129                       |                        | Manufactured  | No          |                     |                  | 120             | Each               | 19.0000        | 1           | 1            |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

Crosstube Material

Location

Loc Qty

Loc Code

LG

19

~~23970~~

2

26550

13

29112

1

34690

3

1 mm 6 11/11/21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|   |  |                                  |
|---|--|----------------------------------|
| <b>DART AEROSPACE LTD</b>                                 |  | <b>Work Order:</b> 746 96        |
| <b>Description:</b> Crosstube Assembly (205/212 High Aft) |  | <b>Part Number:</b> D212-664-241 |
| <b>Inspection Dwg:</b> D212-664-241 Rev: D                |  | <b>Page 1 of 1</b>               |

### FIRST ARTICLE INSPECTION CHECKLIST

|        | Inspection Sheet<br>Drawing Dimension | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 0.200                                 | +/-0.010      | .200                | ✓      |        | vern                    | CWC-08   |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | 2.990                                 | +0.005/-0.000 | 2.992               | ✓      |        | vern                    | CWC-08   |
|        | 5.237                                 | +/-0.030      | 5.240               | ✓      |        | "                       |          |
|        | 2.600                                 | +0.005/-0.000 | 2.605               | ✓      |        | "                       |          |
|        | 2.686                                 | +0.005/-0.000 | 2.689               | ✓      |        | "                       |          |
|        | 2.770                                 | +0.005/-0.000 | 2.775               | ✓      |        | "                       |          |
|        | 2.854                                 | +0.005/-0.000 | 2.857               | ✓      |        | "                       |          |
|        | 2.938                                 | +0.005/-0.000 | 2.943               | ✓      |        | "                       |          |
|        | 3.021                                 | +0.005/-0.000 | 3.024               | ✓      |        | "                       |          |
|        | 3.133                                 | +0.005/-0.000 | 3.137               | ✓      |        | "                       |          |
|        | 3.179                                 | +0.005/-0.000 | 3.183               | ✓      |        | "                       |          |
|        |                                       |               |                     |        |        |                         |          |
| SIDE B | 0.200                                 | +/-0.010      | .200                | ✓      |        | vern                    | CWC-08   |
|        | R0.063                                | +/-0.010      | .063                | ✓      |        | RG                      |          |
|        | 2.990                                 | +0.005/-0.000 | 2.992               | ✓      |        | vern                    | CWC-08   |
|        | 5.237                                 | +/-0.030      | 5.240               | ✓      |        | "                       |          |
|        | 2.600                                 | +0.005/-0.000 | 2.605               | ✓      |        | "                       |          |
|        | 2.686                                 | +0.005/-0.000 | 2.689               | ✓      |        | "                       |          |
|        | 2.770                                 | +0.005/-0.000 | 2.774               | ✓      |        | "                       |          |
|        | 2.854                                 | +0.005/-0.000 | 2.858               | ✓      |        | "                       |          |
|        | 2.938                                 | +0.005/-0.000 | 2.944               | ✓      |        | "                       |          |
|        | 3.021                                 | +0.005/-0.000 | 3.025               | ✓      |        | "                       |          |
|        | 3.133                                 | +0.005/-0.000 | 3.136               | ✓      |        | "                       |          |
|        | 3.179                                 | +0.005/-0.000 | 3.185               | ✓      |        | "                       |          |
|        | 124.362                               | +/-0.020      |                     |        |        | tape                    | MMIL-02  |
|        |                                       |               |                     |        |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |

|                          |                                |                              |     |
|--------------------------|--------------------------------|------------------------------|-----|
| <b>Measured by:</b> MM L | <b>Audited by:</b> [Signature] | <b>Preliminary Approval:</b> | N/A |
| <b>Date:</b> 11/11/21    | <b>Date:</b> 11-11-22          | <b>Date:</b>                 | N/A |

| Rev | Date     | Change                           | Revised by | Approved    |
|-----|----------|----------------------------------|------------|-------------|
| A   | 05.04.27 | New Issue (P/O D412-664-201)     | KJ/JLM     |             |
| B   | 06.03.09 | Tolerance for 5.237 was +/-0.001 | KJ/JLM     |             |
| C   | 07.05.08 | Dwg Rev. updated                 | KJ/JLM     |             |
| D   | 10.08.03 | Dimension 124.362 was 124.36     | KJ         | [Signature] |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



| Item | Qty<br>-241 | Qty<br>-241B | Part Number    | Description   |
|------|-------------|--------------|----------------|---|
| 1    | X           |              | D212-664-241   | CROSSTUBE ASSEMBLY (205/212 HIGH AFT)   |
| 2    |             | X            | D212-664-241B  | CROSSTUBE ASSEMBLY (214 HIGH AFT)   |
| 3    | 1           | 1            | D6006-129      | CROSSTUBE   |
| 4    | 2           | 2            | D2940-1        | SUPPORT   |
| 5    | 4           | 4            | D3595-063-530  | RUBBER CUSHION  |
| 6    | 4           | 4            | MS21920-28     | CLAMP (OR MS21920-30)   |
| 7    | A/R         | A/R          | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023<br>ADHESIVE (TEXTRON/BELL SPEC. 299-947-100,<br>TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.362±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)  
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING  
IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE  
OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS  
AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE  
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR  
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND  
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT  
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74696 M.L.J  
11/10/05

11.08.26  
11.08.26  
UNDER REVIEW  
11.08.13

DEO ATTACHED

RELEASED  
2009-10-29

|            |   |  |              |
|------------|---|--|--------------|
| D          | REFORMAT/REVISE GENERAL NOTES/PART LIST;<br>REORGANIZED VIEWS AND REFORMATTED DRAWING<br>TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2);<br>REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3;<br>C8-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN<br>A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE<br>TO SHEET 4 | RF   | 09.09.30     |
| C          | REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND<br>6398, CUSHION, REVERSE CLAMPS   | PH   | 07.03.08     |
| B          | ADD HOLES FOR COMPATABILITY WITH BHT/AA<br>SKIDTUBES  | PH   | 05.02.04     |
| A          | NEW ISSUE   | PH   | 00.12.12     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | PH  | DART AEROSPACE LTD   |              |
| DRAWN      | RF  | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | PH  | DRAWING NO.  | REV. D       |
| MFG. APPR. | PH  | D212-664-241   | SHEET 1 OF 4 |
| APPROVED   | PH  | TITLE  | SCALE        |
| DE APPR.   | PH  | CROSSTUBE ASSY (205/212 HI AFT)  | NTS          |
| DATE       | 09.09.30  | COPYRIGHT © 2006 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8 7 6 5 4 3 2 1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

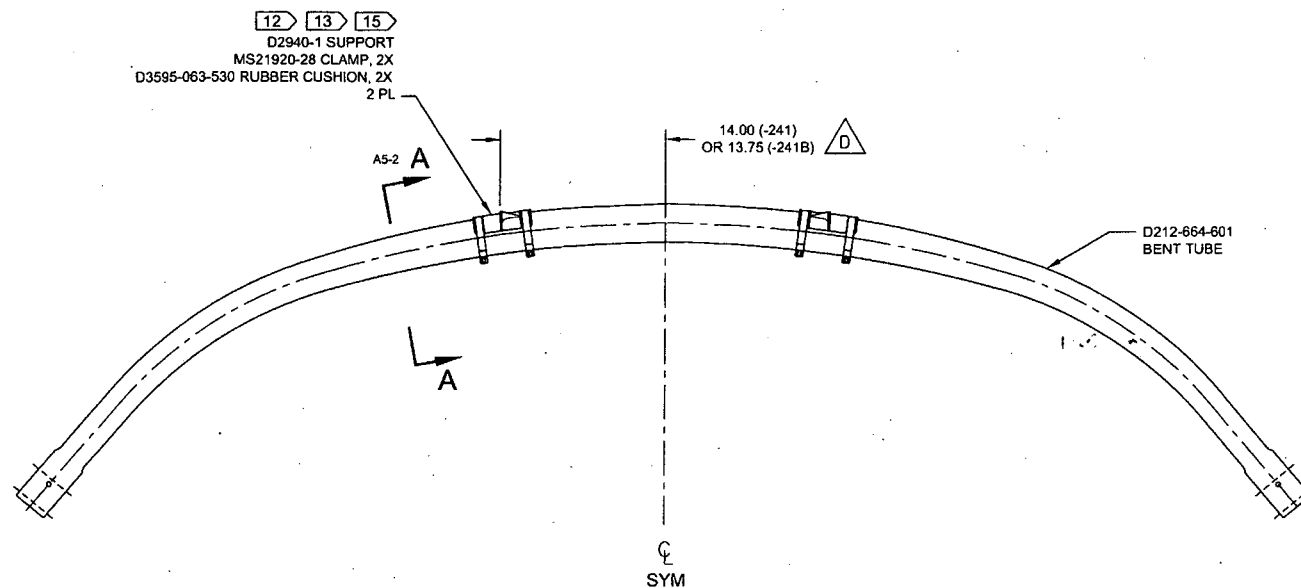
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

74696

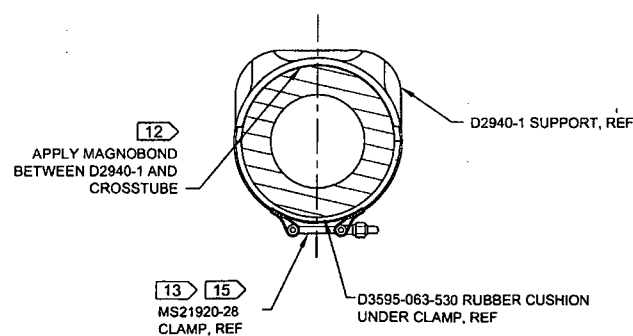


**D212-664-241/-241B  
ASSEMBLY DETAIL**

ECO #11-614  
11.07.26  
**UNDER REVIEW**  
11.06.13

**DEO ATTACHED**

**RELEASED**  
2009-10-28



**SECTION A-A** D6-2  
SCALE 4X

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | RF       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | Q        | DRAWING NO.  | REV. D       |
| MFG. APPR. | DS       | D212-664-241   | SHEET 2 OF 4 |
| APPROVED   | MP       | TITLE  | SCALE        |
| DE APPR.   | HL       | CROSSTUBE ASSY (205/212 HI AFT)  | NTS          |
| DATE       | 09.09.30 | COPYRIGHT © 2000 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

29.77" (756mm)  
TO END OF R102.0 BEND  
ALONG CENTERLINE

20.62" (524mm)  
ALONG CENTERLINE  
OF R35.5 BEND

11.80" REF  
(300mm)

50° ± 2°

R35.5 ± 2.0

R102.0 ± 2.0

CL  
SYM

D212-664-241TRN

Ø0.386<sup>+0.005</sup><sub>-0.000</sub>  
HOLE TO BE ALIGNED WITHIN  
±0.001 OF HOLE ON OTHER  
SIDE OF CUFF

24.30 ± 0.13

25.86 ± 0.13

53.72 ± 0.13

55.03 ± 0.13

110.06 ± 0.25

A4-3

B

B

A7-3

C

C

ECO#11-614  
K07.26

**D212-664-601** 10 D  
**BENDING AND DRILLING DETAIL**

**UNDER REVIEW**  
9/11/66/13

**DEO ATTACHED**

**RELEASED**  
2009-10-29

Ø0.386<sup>+0.005</sup><sub>-0.000</sub>  
HOLE TO BE ALIGNED  
WITHIN ±0.001 OF HOLE  
ON OTHER SIDE OF CUFF  
2 PL

2.500 REF

2.050 ± 0.005

2.500 ± 0.005

0.450<sup>+0.010</sup><sub>-0.005</sub>

90° REF

VIEW C-C: CUFF DETAIL D2-3  
SCALE 3X

Ø3.250 REF

0.515 REF

SECTION B-B D4-3  
SCALE 4X

| DESIGN     | PH         | DART AEROSPACE LTD  |              |
|------------|------------|---|--------------|
| DRAWN      | RF         | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | 9/11/66/13 | DRAWING NO.   | REV. D       |
| MFG. APPR. | 9/11/66/13 | D212-664-241  | SHEET 3 OF 4 |
| APPROVED   | 9/11/66/13 | TITLE   | SCALE        |
| DE APPR.   | 9/11/66/13 | CROSSTUBE ASS'Y (205/212 HI AFT)  | NTS          |
| DATE       | 09.09.30   | COPYRIGHT © 2000 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8 7 6 5 4 3 2 1

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | RF       | <b>HAWKESBURY, ONTARIO, CANADA</b>  |              |
| CHECKED    | Q        | DRAWING NO.   | REV. I       |
| MFG. APPR. | DS       | D212-664-241  | SHEET 3 OF 3 |
| APPROVED   | AO       | TITLE   | SCALE        |
| DE APPR.   | JL       | CROSSTUBE ASSY (205/212 HI AFT)   | NT           |
| DATE       | 09.09.30 | COPYRIGHT © 2000 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO YOU FOR INFORMATION FROM IT.<br>IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Side A

| R1     | R2     |
|--------|--------|
| 1-.239 | 1-.353 |
| 2-.276 | 2-.346 |
| 3-.248 | 3-.361 |
| 4-.250 | 4-.376 |

Side B

| R1     | R2     |
|--------|--------|
| 1-.241 | 1-.351 |
| 2-.252 | 2-.340 |
| 3-.247 | 3-.365 |
| 4-.255 | 4-.378 |

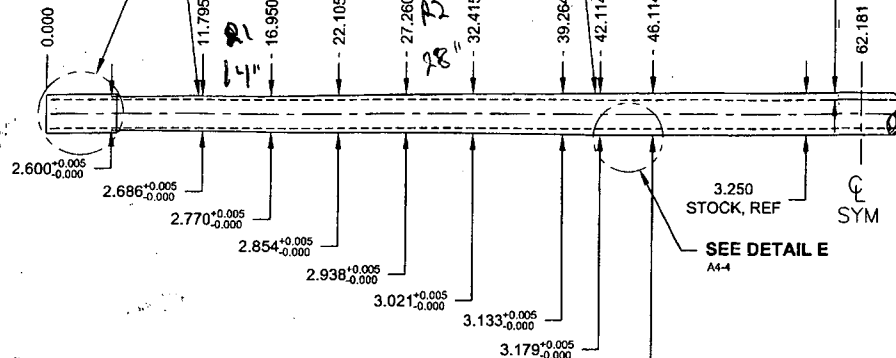
74696

R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

0.515 WALL  
STOCK, REF

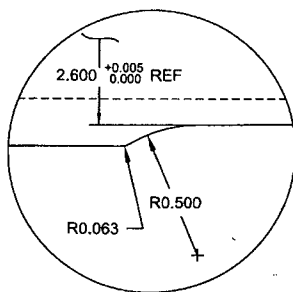
SEE DETAIL D



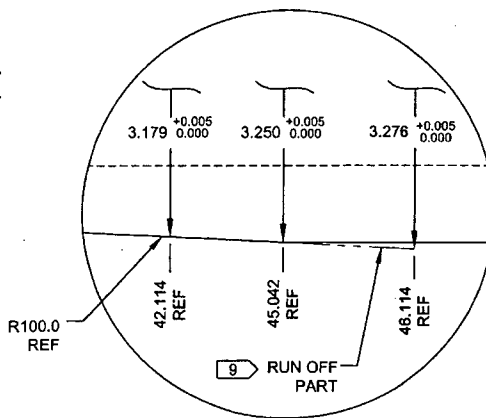
TAPER UNIFORMLY FROM  
3.179<sup>+0.005</sup>/<sub>-0.000</sub> THROUGH TO 3.276<sup>+0.005</sup>/<sub>-0.000</sub>  
RUNNING OFF PART

D

**D212-664-241TRN**  
**TURNING DETAIL**

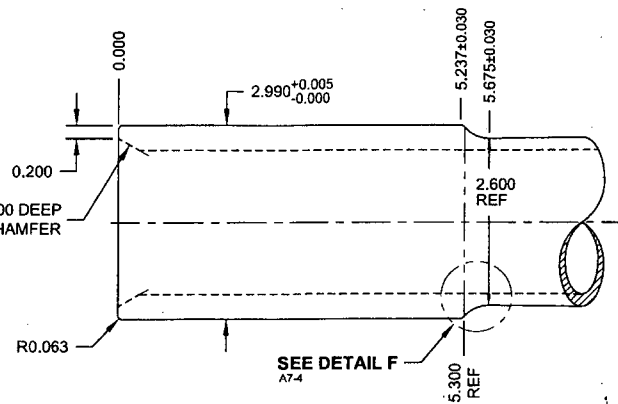


**DETAIL F:**  
**CUFF TRANSITION** C2-4  
SCALE 10X



**DETAIL E:**  
**TAPER RUN-OFF** C5-4  
NOT TO SCALE

9  
30° X 0.500 DEEP  
CHAMFER



**DETAIL D:**  
**CROSSTUBE CUFF** D8-4  
SCALE 5X

REV 11-614  
11.07.28

UNDER REVIEW

DEO ATTACHED

RELEASED  
2009-10-29

|  |          |  |              |
|--|----------|--|--------------|
| DESIGN   | PH       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  | RF       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  | Q        | DRAWING NO.                            | REV. D       |
| MFG. APPR.   | DS       | D212-664-241                           | SHEET 4 OF 4 |
| APPROVED   | AP       | TITLE                                  | SCALE        |
| DE APPR.   | TH       | CROSSTUBE ASS'Y (205/212 HI AFT)       | NTS          |
| DATE   | 09.09.30 | COPYRIGHT © 2000 BY DART AEROSPACE LTD |              |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |          |  |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

74696

|                             |  |               |   |               |                                |                           |              |
|-----------------------------|--|---------------|---|---------------|--------------------------------|---------------------------|--------------|
| DRAWING NO.<br>D212-664-241 | TITLE<br>CROSSTUBE ASSY (205/212 HI AFT) | REV. D        | DART AEROSPACE LTD<br>ENGINEERING ORDER |               | D.E.O. NO.<br>D212-664-241-D-1 | SHEET NO.<br>SHEET 1 OF 2 | SCALE<br>NTS |
| DRAWN                       | CHECKED                                  | MFG. APPR.    | APPROVED                                | DE APPR.      |                                |                           |              |
| DATE 11.04.07               | DATE 11.04.11                            | DATE 11.04.12 | DATE 11/04/12                           | DATE 11.04.12 |                                |                           |              |

**PURPOSE:**

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

**CHANGE:**

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

**IS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND  
PAINT OUTSIDE PER DART QSI 005 4.2  
REMOVE MASKING AND APPLY CLEAR COAT

**WAS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2

RELEASED  
2011-04-18

UNDER REVIEW

11.16.13

RCN#1-614

11.07.28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

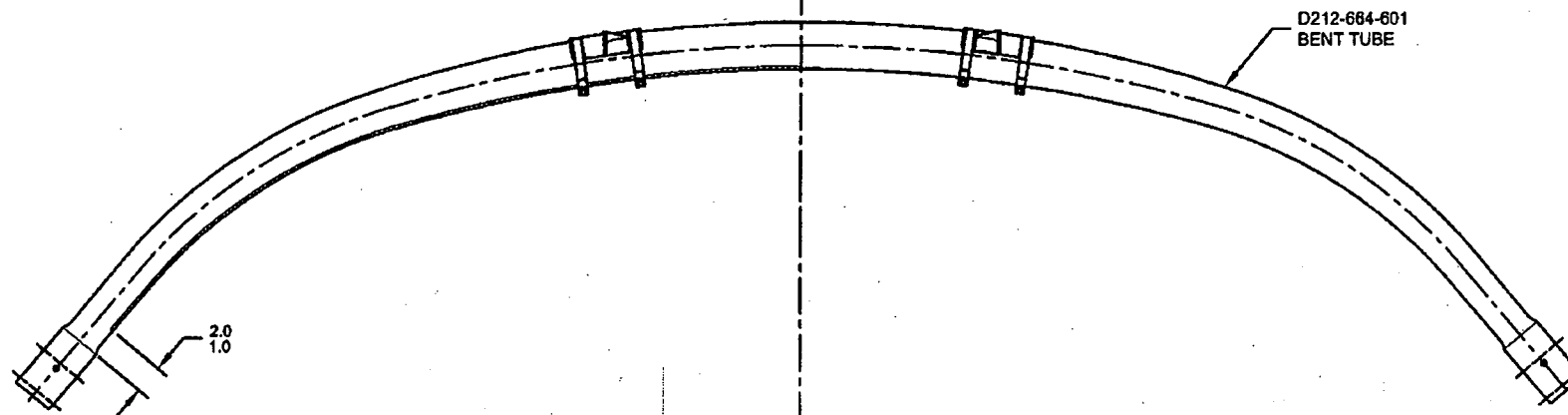
**NOTE:** Date & initial all entries

74696

|                             |  |        |   |  |                                |                           |              |
|-----------------------------|--|--------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO.<br>D212-664-241 | TITLE<br>CROSSTUBE ASSY (205/212 HI AFT) | REV. D | DART AEROSPACE LTD<br>ENGINEERING ORDER |  | D.E.O. NO.<br>D212-664-241-D-1 | SHEET NO.<br>SHEET 2 OF 2 | SCALE<br>NTS |
| DRAWN                       | CHECKED                                  |        | MFG. APPR.                              |  | APPROVED                       | DE APPR.                  |              |
| DATE 11.04.07               | DATE 11.04.11                            |        | DATE 11.04.12                           |  | DATE 11/04/12                  | DATE 11.04.12             |              |

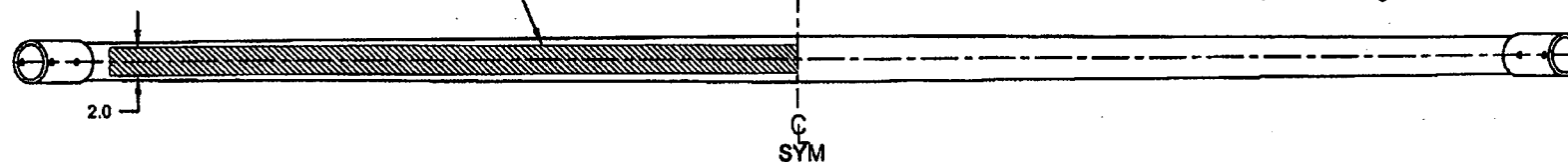
**IS:**

**WAS:**



**D212-664-241/-241B  
ASSEMBLY DETAIL**

MASK AREA PRIOR TO PAINTING,  
REMOVE MASKING AFTER PAINT  
AND APPLY CLEAR COAT



**RELEASED**  
2011-04-18

**UNDER REVIEW**

11.06.13  
11.07.12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

74696

|                             |   |                     |   |                   |                                |                           |              |
|-----------------------------|---|---------------------|---|-------------------|--------------------------------|---------------------------|--------------|
| DRAWING NO.<br>D212-664-241 | TITLE<br>CROSSTUBE ASS'Y (205/212 HI AFT) | REV. D              | <b>DART AEROSPACE LTD<br/>ENGINEERING ORDER</b> |                   | D.E.O. NO.<br>D212-664-241-D-2 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN <i>q</i>              | CHECKED <i>ASS</i>                        | MFG. APPR. <i>8</i> | APPROVED <i>MP</i>                              | DE APPR. <i>#</i> |                                |                           |              |
| DATE 11.07.15               | DATE 11.07.20                             | DATE 11.07.21       | DATE 11/27/21                                   | DATE 11.07.21     |                                |                           |              |

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:**

IS:

| Item | Qty<br>-241 | Qty<br>-241B | Part Number     | Description                   |
|------|-------------|--------------|-----------------|-------------------------------|
| 7    | A/R         | A/R          | PROSEAL 890 B-2 | SEALANT, AMS-S-8802 CLASS B-2 |

WAS:

|   |     |     |                |   |
|---|-----|-----|----------------|---|
| 7 | A/R | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023<br>ADHESIVE (TEXTRON/BELL SPEC. 299-947-100,<br>TYPE II, CLASS 2 ADHESIVE) |
|---|-----|-----|----------------|---|

NOTE 12 &amp; 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2940-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
2011-07-28  
*WKS*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries